

ORDER 4619 30 NOV



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3078-041
Job Sheet 179302



Part No: D3078-041

Job Qty: 4 ea

Part Name: Step Assembly, Hi Short LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A 15.11.12 NEW ISSUE DD VERF:JLM IPP REV:B 16.03.15 DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Large Fab-4		MAV 18-10-31
110	Large Fab	4 pcs	7/6/18	7/6/18	0.00	4.04	Large Fab 8		MAV 18-10-31
120	QC	4 pcs	7/6/18	7/6/18	0.00	0.00	QC6	DAS 43	CPC
130	Large Fab	4 pcs	7/6/18	7/6/18	0.00	4.04	Large Fab 2	9-30	CPC
140	QC	4 pcs	7/6/18	7/6/18	0.00	0.00	QC9		CPC
150	QC	4 pcs	7/6/18	7/6/18	0.00	0.00	QC5		CPC
160	HandFinish	4 pcs	7/6/18	7/6/18	0.00	0.47	HandFinish1		D.R 18/11/12
170	QC	4 pcs	7/6/18	7/6/18	0.00	0.00	QC7-2		CPC
200	Large Fab	4 pcs	7/6/18	7/6/18	0.00	4.04	Large Fab 2		CPC
210	QC	4 pcs	7/6/18	7/6/18	0.00	0.00	QC10		JS
220	QC	4 pcs	7/6/18	7/6/18	0.00	0.00	QC5		JS
240	HandFinish	4 pcs	7/6/18	7/6/18	0.00	0.47	HandFinish6		D.R 18/11/19
250	Powdercoat	4 pcs	7/6/18	7/6/18	0.00	0.91	Powdercoat1		DEF 18-11-20
260	HandFinish	4 pcs	7/6/18	7/6/18	0.00	0.47	HandFinish3		JS 18-11-20
270	QC	4 pcs	7/6/18	7/6/18	0.00	0.00	QC3		38
290	Packaging	4 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-1		DAS 38 NOV 2 2 2018
300	QC21-SA	4 Ea	7/6/18	7/6/18	0.00	0.00	QC21		21 NOV 2 2 2018

Part Op 110 - 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680
Descriptions: for rivets. 3-Deburr

130 - 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R
Aluminum Rod m134783 3-Grind End Plate flush

200 - 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024
4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 5-Grind End Plate flush

m134951 250 - START TIME: 2:35 OVEN TEMPERATURE: 320° FINISH TIME: 3:05

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (.5 ea)	90-Start up Operation	5104067
D3067-1	End Plate	8 Ea (2 ea)	130-Large Fab	5104284
D3219-3	Plate	8 Ea (2 ea)	130-Large Fab	5107461
D3065-041	Step Leg Assembly	4 Ea (1 ea)	200-Large Fab	5126166
D3066-1	Spacer	8 Ea (2 ea)	200-Large Fab	5101804
MS20600-AD4W4	Rivet	64 Ea (16 ea)	200-Large Fab	5117999

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	55	0
130-Large Fab	D3067-1	8	214	0
	D3219-3	8	47	0
	D3065-041	4	0	0
200-Large Fab	D3066-1	8	209	0
	MS20600-AD4W4	64	3,836	0

Part Specifications

Specifications could not be found.

Plex 6/18/18 10:34 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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 Hawkesbury, ON K6A 1K7
 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S122924



Part: D3078-041

Job No: 179302

Serial No/Batch: S122924

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/30/18

ULT CATEGORY

☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Dimensions
☐ Grain	☐ Over/Under tolerance
☐ Weld	☐ Part Incorrect
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Misabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence